∾Date: User: Thursday, 16/10/2008 10:45:41 AM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 42631

Estimate Number P.O. Number

This Issue

: 16/10/2008

Prsht Rev. : NC

First Issue : 42361 **Previous Run**

: 11

: 10313

Туре

S.O. No. :

: SMALL /MED FAB

Part Number

Drawing Name

Drawing Number

: D26483 . D2648 REV D : N/A

: D

: WEARPAD

Project Number

Drawing Revision

Material

KJ/RF

: 31/10/2008 **Due Date**

Qty:

40 Um:

Each

Written By **Checked & Approved By**

Comment

Re-format; Incorporated D2648-1 : Est: E 02.09.18

Est Rev:F Now on Wateriet 06-08-14

JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S16GA

1010/1025 sheet 16GA



Comment: Qty.:

0.0788 sf(s)/Unit Total:

3.1500 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: 105

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

Dwg Rev:_

Prog Rev:_

188-11-6





2-Deburr if necessary



IR 8-116



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIÚM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary



Dart Aerospace Ltd

		- -							
W/O:			WC	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							<u> </u>		
Part No		PAR #:							
	R	esolution:	Dispositio	າ:	QA: N/C	Closed:		Date: _	
NCR:		\	WORK ORDI	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC			ction B	Ve	rification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n & (Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Thursday, 16/10/2008 10:45:41 AM ate: Úser: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: WEARPAD Job Number: 42631 Part Number: D26483 Job Number: Seq.#: Description: **Machine Or Operation:** 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Description Batch Qty M109560 A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary VISUAL INSPECTION OF GROUND WELDS 8.0 QC10 Comment: VISUAL INSPECTION OF GROUND WELDS INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 10.0 POWDER COATING 06442 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: OVEN TEMPERATURE: FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSIO 11.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 12.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Form: rprocess

Page 2

Dart	Aeros	pace	Ltd
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	. oopaoo								
W/O:			V	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
W-W									
							!		
Part No		PAR #:							
	R	esolution:	Disposit	ion:	_ QA: N/C C	losed:		Date: _	
NCR:		\	WORK OR	DER NON-CONFORMA	ANCE (NCI	7)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date: User: Thursday, 16/10/2008 10:45:41 AM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 42631

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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W/O:			WC	ORK ORDER CHANG	GES					
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Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Dispositio	n:	QA	N/C CI	osed:		Date: _	
NCR:	,		WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	CTED	Description of NC			ction B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector
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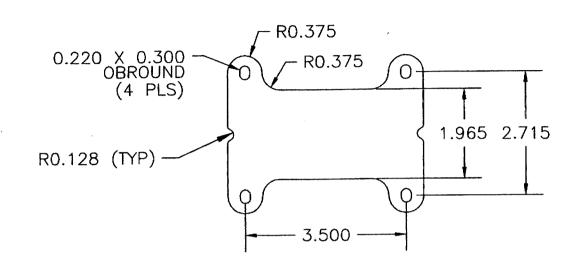
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: Д2の	3
Description: Wearpad	Part Number: D26	48-3
Inspection Dwg: D2648 Rev: D	Page	1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

			X	First Article	е	Prototy	ype			
1	wing ension		Tolerance	Actual Dimension	Accept	Reject	Method Inspecti		Cor	nments
1.5	965		+/-0.010	1,966	K					
2.	715		+/-0.010	2,713	X			·		· · · · · · · · · · · · · · · · · · ·
3.	500		+/-0.010	3.497	y					
0.220	x 0.300	Ţ.	+/-0.010 x +/-0.010		Se.					
R0	.375		+/-0.010	375	7 0					
R0	.128		+/-0.010	861.	<i>X</i> o					
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Measu	Measured by:			Audited by:			Prototy	ре А	pproval:	N/A
	Date:	9	6-11-6	Date:	108.11	·ST			Date:	N/A
Rev	Date	;	Change	<u></u>				Re	vised by	Approvød
A	06.10.		New Issue					KJ	JLM o	ad

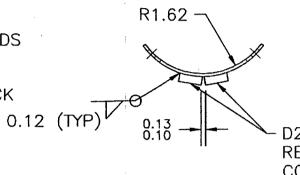
D2648-1 FLAT PATTERN



SECTION A-A R1.62

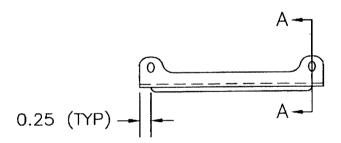
7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B

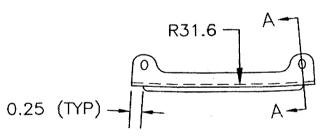


- D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

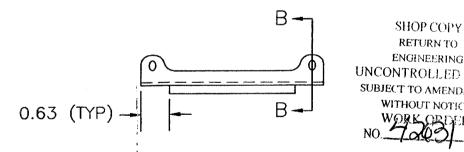
(MADE FROM D2648-1)

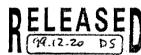


D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







	•	
D.	99.11.17	ADDED D2648-7
С	, 97.06.26	R31.6 WAS R19.6
В	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
Α	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC
CHECKED	APPROVED	DRAWING NO. REV.
册	#	D2648 SHEET 1 OF
DATE	1 V	TITLE SCA
99.11.17		WEARPAD 1

BREAK ALL SHARP CORNERS 0.063 MAX

MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)

FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES